

Date: Monday, 16/10/2006 7:48:36 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 28948	
Estimate Number : 10224	
P.O. Number : <i>N/A</i>	Part Number : D2143
This Issue : 16/10/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2143 REV. C1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 28948	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 19/10/2006 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est C 00.05.18 Added inspection level 8 EC	
Est Rev:D Now on WaterJet 06-10-15 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0693 sf(s)/Unit Total : 2.7720 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
(M5052H32S.040)Batch: *M101875 ML 061018*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: *C1*Prog Rev: *C1*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

~~Tumble and Deburr~~*Deburr**ML 06/10/20*

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6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D2143

SD 04/10/24 (40)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10.24 (40)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

MM

06/10/25

(40)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

yl 06/10/26 x 40

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Pl 6/10/27 (40)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 25

Pl 6/10/27 (40)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/10/27

Job Completion

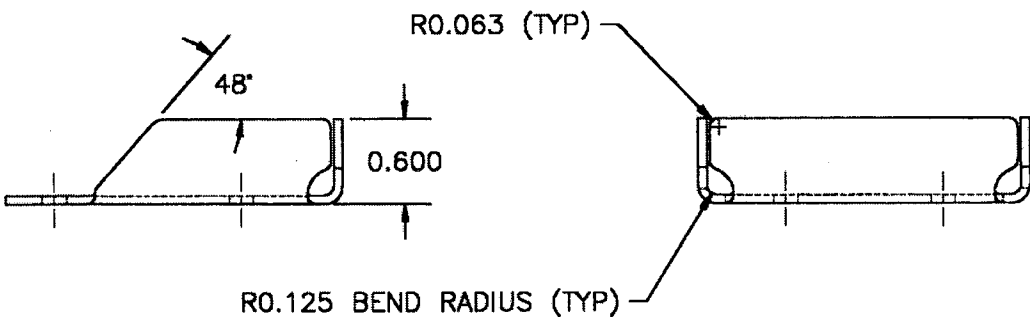
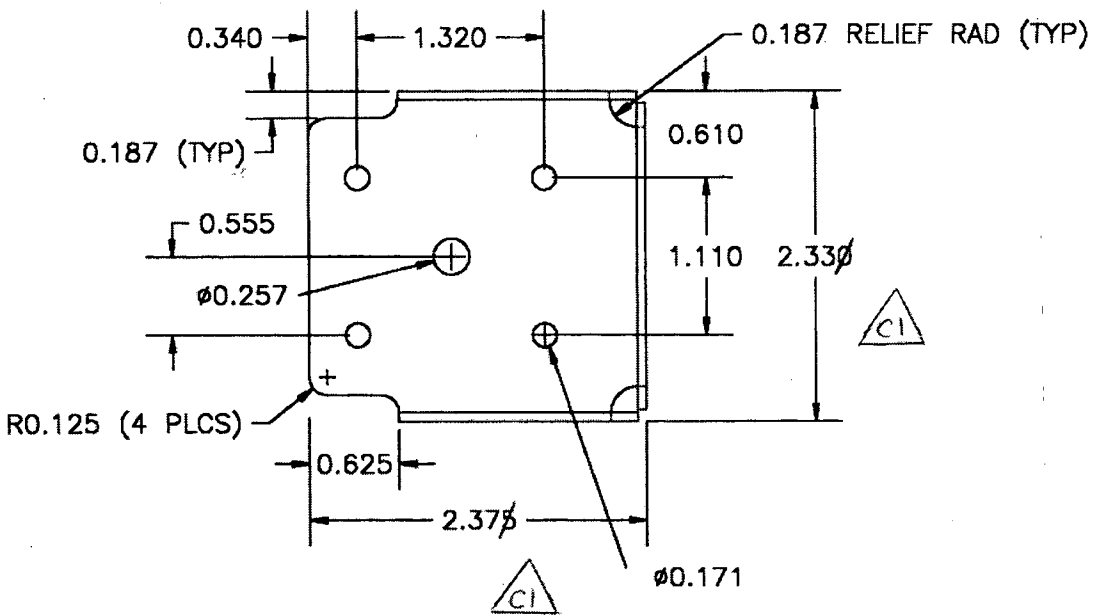


C 206/10/27



RELEASED
96.06.20 13.03

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND		
CHECKED B	APPROVED K	DRAWING NO. D2143	SHEET 1 OF 2
DATE 92.07.10		TITLE HINGE BRACKET	SCALE
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
CI	04.06.15	UPDATE DIMENSIONS	



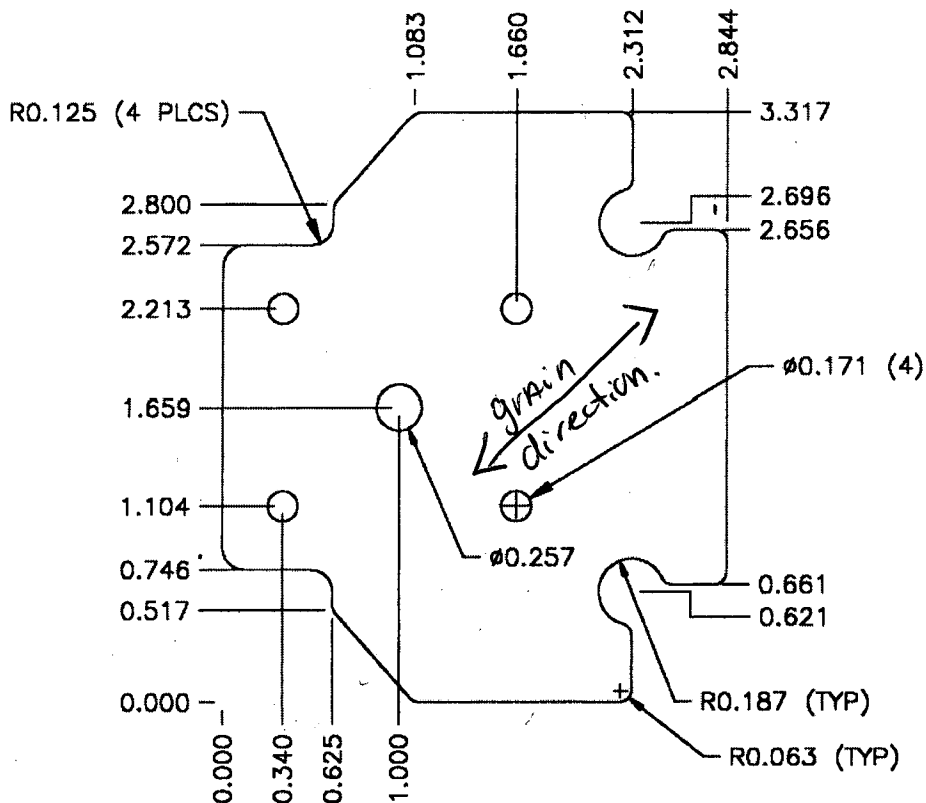
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

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WITHOUT NOTICE
WORK ORDER
NO. 28948



DESIGN J BRADLEY	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2143	REV. a SHEET 2 OF 2
DATE 95:10:18	TITLE HINGE BRACKET FLAT PATTERN		SCALE 1:1

RELEASED
96 (56 20 BW)



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WORK ORDER
NO. 38948
diagonal grain direction.

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317